

Date: Monday, 9/10/2007 1:18:58 PM
User: Kim Johnston

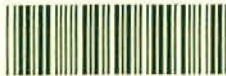
Process Sheet

Split 2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 34475		
Estimate Number	: 12882		
P.O. Number	: <i>N/A</i>	Part Number	: D3560042
This Issue	: 9/10/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3560 UNDER REVIEW
First Issue	: <i>NA</i>	Project Number	: <i>N/A</i>
Previous Run	: 32645	Drawing Revision	: <i>BC</i>
		Material	: <i>N/A</i>
Written By	:	Due Date	: 9/17/2007
Checked & Approved By	:	Qty:	<i>58</i> Um: Each
Comment	: Est Rev:A New Issue 07.05.24 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
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Comment: Qty.: 1.4648 f(s)/Unit Total: 17.5770 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: *M105646*

7/10/20

(12)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks 16.750" long

7/10/20

(12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: *AA* & Dwg D3560 Rev: *C*

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

5.1 07/09/21

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.1 04/09/21

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.1 07/09/21

(12)

Date: Monday, 9/10/2007 1:18:58 PM
User: Kim Johnston

Process Sheet

SPLIT-2

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34475

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

PLATE

B34260

B34478 (5)

07-10-25

07-10-10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

07-10-25 (5)

07-10-10

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/26 (5)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-26 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

see QC after Alodine

07-10-26 (5)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07/10/26

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/10/26 (5x)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WAT

07-10-26 (5)



Date: Monday, 9/10/2007 1:18:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34475

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(5)
Don 10/26

Job Completion



11/07/07

DART AEROSPACE LTD		Work Order:	34475
Description: Arm		Part Number:	D3560-2
Inspection Dwg: D3560	Rev: B	Page 1 of 1	

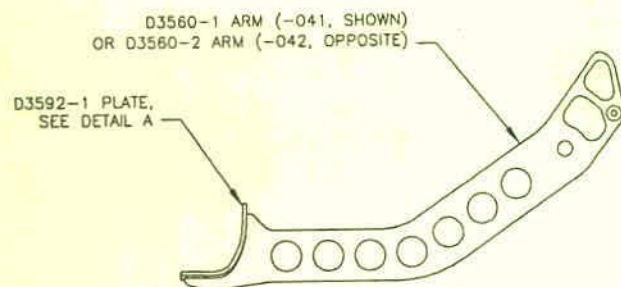
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

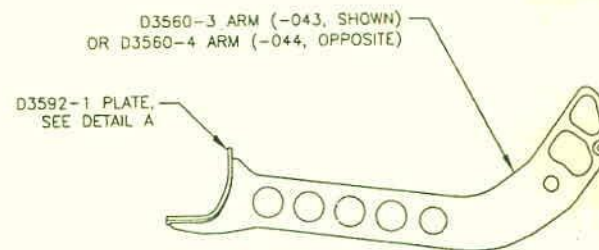
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5063	✓			
Ø0.196	+0.005/-0.001	.197	✓			
Ø1.000	+0.010/-0.001	1.001	✓			
0.500	+/-0.010	.495	✓			
0.250	+/-0.010	.250	✓			
0.275	+/-0.010	.276	✓			
0.188	+/-0.010	.192	✓			
2.000	+/-0.010	2.001	✓			
1.700	+/-0.010	1.700	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.380 x 100°	✓			
0.250 Deep	+/-0.010	.250	✓			

Measured by: JL	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/07/21	Date: 07/07/21	Date:	N/A

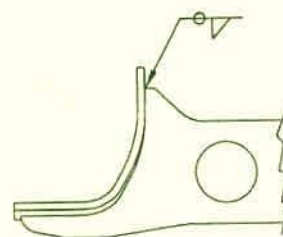
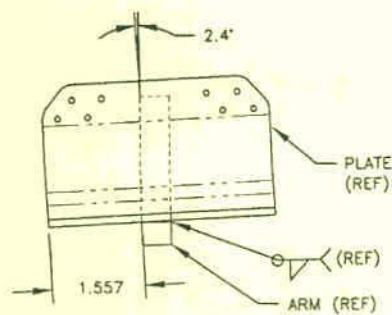
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM [Signature]	[Signature]



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.19

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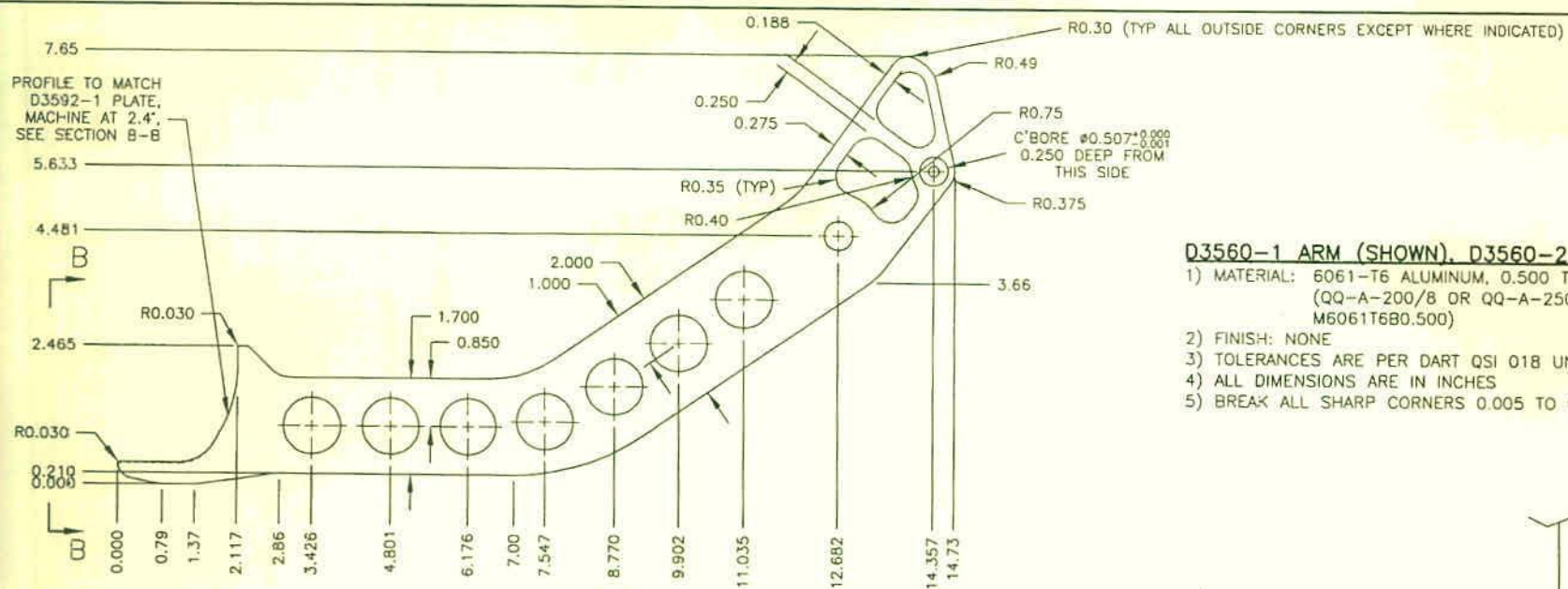
C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	9P	DRAWN BY 9P
CHECKED	H	APPROVED H
DATE	07.06.19	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. C
		SHEET 1 OF 3
		SCALE 1:4

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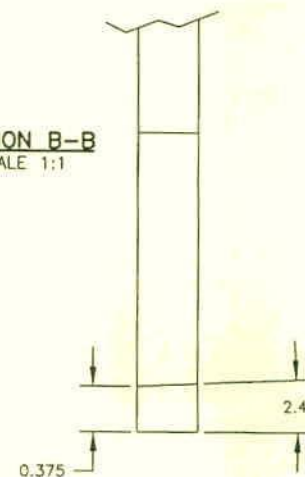
1950



D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B SCALE 1:1



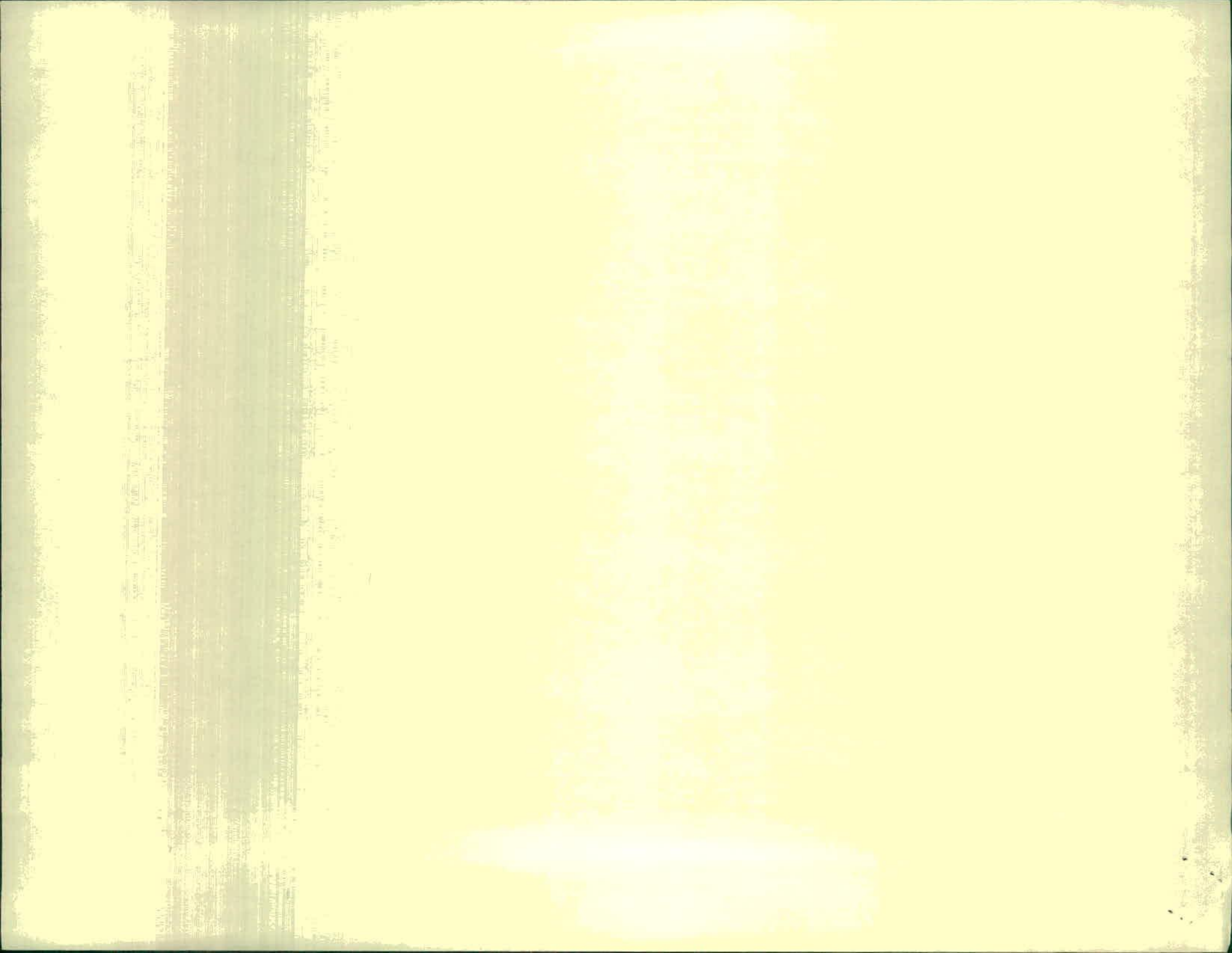
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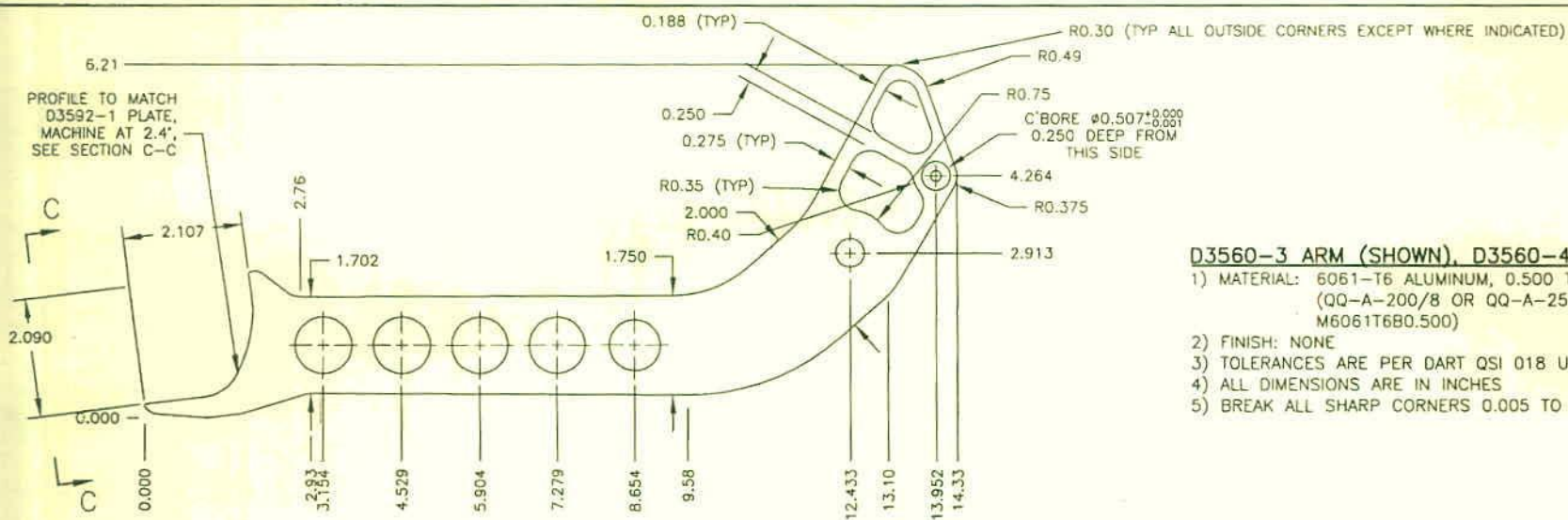
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CHECKED	APPROVED	DRAWING NO. D3560	REV. C SHEET 2 OF 3
DATE 07.06.19		TITLE ARM WELDMENT	SCALE 1:2

NO. 34475
WORK ORDER
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D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION C-C VIEW ROTATED SCALE 1:1



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07.06.19

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CHECKED	40	APPROVED	40	DRAWING NO.	REV. C
DATE	07.06.19	TITLE	ARM WELDMENT	D3560	SHEET 3 OF 3
					SCALE
					1:2

